

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028273**Date Inspected:** 26-Aug-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job site**CWI Name:** Salvador Merino**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QAI) Rodney Patterson was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

OBG 13E Deck Drop-in (13E-PP120.6)

This QA randomly observed ABF/JV QC inspector Harry Scharein performing Ultrasonic Testing (UT) of the deck panel drop-in longitudinal weld splice designated as 13E-PP120.6. The locations ultrasonically tested were in way of repairs performed and completed more than 24 hours prior. No rejectable indications were observed by the QC at the time of inspection.

Ultrasonic Testing OBG

This QA performed verification Ultrasonic Testing (UT) on Complete Joint Penetration (CJP) deck panel drop-in edge plate and deck splice welds. The welds were previously tested and accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QAI's findings are as follows;

Lift 13E Transverse Deck Splice (Weld No. 13E-120.6)

The QAI performed a minimum of 50% verification of this weld. No rejectable indications were found at the time of inspection.

Lift 13W Edge Plate Splice (Weld No. 13W/14W-G)

The QAI performed a minimum of 50% verification of this weld. No rejectable indications were found at the time

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of inspection.

Lift 13W Edge Plate Splice (Weld No. 13W-PP122.2-G)

The QAI performed 100% verification of this weld. No rejectable indications were found at the time of inspection.

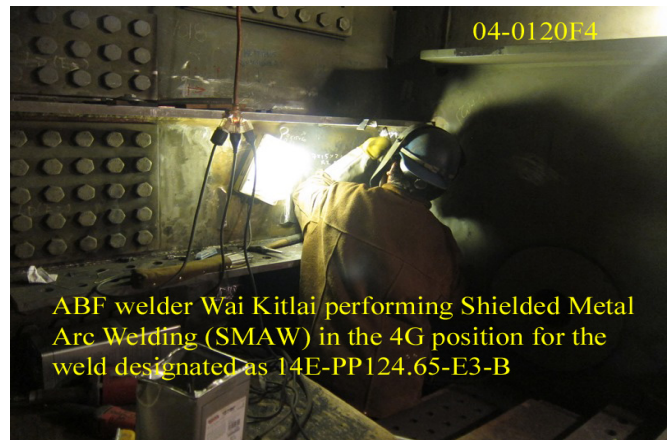
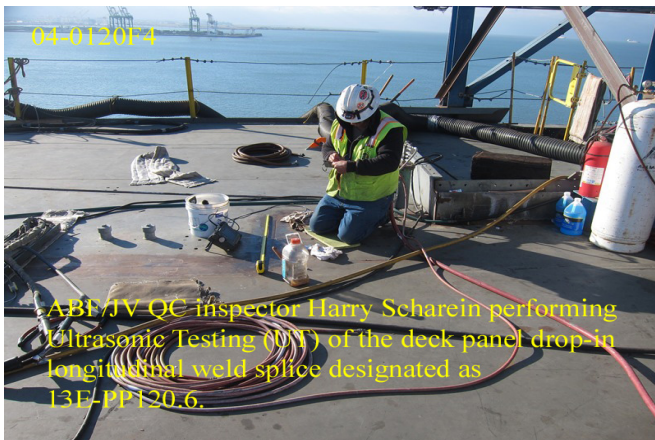
The QAI observed the ABF welder Wai Kitlai performing Shielded Metal Arc Welding (SMAW) in the 4G position utilizing the Caltrans approved Welding Procedure Specifications ABF-WPS-D1.5-1004-Repair at the E3 longitudinal diaphragm stiffener connections at panel point 124.65. The welds are designated as 14E-PP124.65-E3-B and 14E-PP124.65-E3-D. The weld and surrounding area was brought to temperature by the use of a gas torch. The Quality Control (QC) inspector Salvador Merino was observed monitoring the welding parameters at the beginning of the shift. The repairs at this location are being conducted in accordance with RWR-201208-081 and RWR-201208-082.

The QAI spent a portion of this shift reviewing and documenting the status and completion of various production welding tracking logs for lift 13E-14E drop-in deck work currently in-process. The QA recorded the information on the OBG tracking log.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Patterson,Rodney

Quality Assurance Inspector

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Reviewed By: Levell,Bill

QA Reviewer